

AMENDMENTS TO THE SPECIFICATION:

Please replace the paragraph beginning at page 2, line 16 with the following:

The proposed object is met according to the present invention in that the inner geometrical shape of the inner cross-section shape of the mold and the corresponding dimensions thereof are analogous to a curve of the locally deducible quantity of solidification heat for a specified casting rate and analogous to the expansion of the tubular mold. The tubular mold is thereby adapted so as to optimize the process, wherein the solidification heat is dissipated according to a (high) casting rate based on the mold height (mold length) both by means of the casting contraction behavior as well as the mold expansion during casting operation.

Please replace the paragraph beginning at page 3, line 4 with the following:

The casting shell always advantageously abuts the inner surface (hot side) of the mold without air gaps. This makes it possible, for example, to take into account the magnified heat

quantity in the casting surface mirror area for casting contraction and mold expansion. The tubular mold is designed with regard to its inner shape and dimensions based on these values. The values can be used for example for mold heights of approximately 1000-1100 mm.

Please replace the paragraph beginning at page 3, line 20 with the following:

A very pronounced contraction can be accomplished, for example, in that the tubular mold in the area of the casting surface mirror exhibits a section of greater conicity in accordance with the greater contraction of the continuous casting.

Please replace the paragraph beginning at page 4, line 21 with the following:

Taking into account the decreasing contraction according to the respective casting shell thickness, it is further provided that the approximately parabola-shaped recess formed in the wall of the casting by the contraction declines in the direction toward the casting exit side. This makes it possible to carry out

HM-648

an individualized adjustment to the respective broadside and/or narrowside of the entry cross-section.

Please replace the paragraph beginning at page 5, line 11 with the following:

In a further embodiment a ~~plane-parallel~~ surface is provided in the area of each corner radius which is plane-parallel and opposes analogous counter surfaces in the inner cross-section form.

Please replace the paragraph beginning at page 6, line 18 with the following:

On the right side across the mold height 11 there is a diagram "D" showing ~~the process during~~ the dissipation of solidification heat from the continuous casting 1. The dramatically increasing temperature distribution in the area of the casting surface mirror results therefrom.

Please replace the paragraph beginning at page 7, line 1 with the following:

HM-648

The tubular mold 2 is built such that the inner geometrical cross-section shape 9 of the mold and the associated dimensions 10, 10' thereof are set analogous to the locally deducible quantity of solidification heat (see Fig. 1, right diagram "D") for a specified (high) casting rate and analogous to the expansion of the tubular-mold 2, i.e., designed based on calculations and/or experience.

Please replace the paragraph beginning at page 7, line 8 with the following:

The exterior form 12 is thereby reduced at least in separate height ranges ~~12~~ 12' of the tubular mold 2 analogous to the thermal expansion of the mold.

Please replace the paragraph beginning at page 8, line 10 with the following:

In Figs. 4 and 4A a centric, approximately parabola-shaped, recess 20 is arranged on each cross-section side 3a of the mold starting at ~~an~~ the entry cross-section 3. The parabola-shaped recess 20 diminishes in depth and thus in width downwards in the direction toward the casting exit side 7.

Please replace the paragraph beginning at page 8, line 15 with the following:

The length 20a of the parabola-shaped recess 20 thereby extends approximately into half the height of the mold 11. The length 20a of the parabola-shaped recess 20 is also adapted to an amount of contraction of amount for the height of the respective broadside and/ narrowside 21 of the mold cross-section 22 (Fig. 4A).

Please replace the paragraph beginning at page 8, line 21 with the following:

In the area of each corner radius 8 there is one plane-parallel surface 23 extending downwards, and each opposing a respective analogous opposing counter surface 24 in the inner cross-section shape 9, the surfaces 23 and 24 being plane-parallel.